

Work Order ID 100289-2 *SPLIT* *(6)*

100289

Page 1

Item ID: D2571

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Fwd Out 205

Start Date: 4/25/13 Start Qty: 12.00

6 *12*

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: *ML5*

Date: *1304-24*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2571

F

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. *100289*

Double check by: *[Signature]*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect

13-05-20

6

110

0.00

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine keyway as per dwg D2571 & D2572

13-03-24

6

Work Order ID 100289

April-22-13 12:52:50 PM

100289

Page 2

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N900040100

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Start Date: 4/25/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

13-05-20

6

2

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

13-5-27

6

1

DAS
04
2-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

6 13-5-27

Work Order ID 100289

April-22-13 12:52:50 PM

100289

Page 3

Item ID: D2571

Accept

N900040100

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Revision ID:

Item Name: Saddle, Pwd Out 205

Stop *NS2*

Start Date: 4/25/13 Start Qty: 12.00

12

Required Date: 5/03/13 Req'd Qty: 12.00

12

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:45
3200F
8:15

6x pf m/f 13/05/28

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

6x d ll 13/05/28

170

Identify as per dwg & Stock Location: 8441

0.00

170

Packaging

Memo

0.00

Packaging

6x

8P
13-5-28

Picklist Print

April-22-13 12:52:49 PM

Page 1

Work Order ID: 100289

Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 4/25/13

Required Date: 5/03/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 102.10.02Re-format: Change to Dwg Rev. D & incorporated D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007 Saddle Billet		Manufactured	No			100	Each	37.0000	1	12		13-05-19	

Location

Loc Qty

Loc Code

MAT041

36

85432

1

88516

4

89349

3

92730

20

98465

8

MAT042

1

85432

1

99174

12

DART AEROSPACE LTD	Work Order:	100785
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.439	.438	.438	.438		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		8.000	7.999	8.000	8.000		
F	0.490	0.510		.499	.501	.502	.502		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.501	.500	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.567	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.498	2.500	2.500	2.500		
O	3.869	3.879		3.871	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.124		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.250	.251	.250	.248		
S	0.115	0.135		.120	.125	.125	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.237	.240	.238	.242		
W	0.115	0.135		.110	.121	.121	.121		
X	0.308	0.313		.309	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.361	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.628	.627	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.251	.249	.251		
AE	1.375	1.395		1.391	1.387	1.389	1.385		
AF	0.115	0.135		.126	.130	.130	.130		
AG	0.240	0.280		.255	.260	.260	.260		
AH	0.240	0.260		.246	.249	.248	.251		
AI	2.000	2.020		2.006	2.003	2.006	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	AS
Date:	13-05-20

Audited by:	DAS
Date:	04-05-20

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order:	100289
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	A5	A6	A7	A8		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.748	1.748		
C	3.495	3.505		3.500	3.500	3.498	3.498		
D	1.745	1.755		1.750	1.750	1.748	1.748		
E	7.990	8.010		7.997	8.009	7.999	7.998		
F	0.490	0.510		.500	.501	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.498	.500	.4995		
J	1.174	1.184		1.179	1.179	1.176	1.176		
K	0.558	0.578		.568	.566	.566	.5645		
L	1.174	1.184		1.179	1.179	1.176	1.176		
M	1.490	1.500		1.495	1.495	1.493	1.493		
N	2.495	2.505		2.500	2.500	2.496	2.498		
O	3.869	3.879		3.874	3.874	3.871	3.872		
P	0.115	0.135		.125	.125	.126	.126		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.249	.250	.250	.249		
S	0.115	0.135		.125	.127	.122	.121		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.241	.239	.240		
W	0.115	0.135		.121	.122	.121	.121		
X	0.308	0.313		.312	.311	.312	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.364	.364	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.6275	.628	.627	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.252	.250	.250	.253		
AE	1.375	1.395		1.390	1.388	1.3865	1.386		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.251	.250	.250		
AI	2.000	2.020		2.009	2.003	2.001	2.0007		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: <i>JS</i>	Audited by: <i>DAS</i>
Date: 13-5-22 / 13-05-23	Date: 13-5-24

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	<i>KA</i>

DART AEROSPACE LTD		Work Order:	100289
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.997	7.999	7.999	7.999		
F	0.490	0.510		.499	.498	.499	.501		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.499	.4985	.498		
J	1.174	1.184		1.177	1.178	1.177	1.178		
K	0.558	0.578		.565	.565	.5655	.565		
L	1.174	1.184		1.177	1.178	1.177	1.178		
M	1.490	1.500		1.494	1.4935	1.493	1.494		
N	2.495	2.505		2.498	2.497	2.497	2.497		
O	3.869	3.879		3.873	3.872	3.872	3.872		
P	0.115	0.135		.125	.126	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.249	.248	.249		
S	0.115	0.135		.122	.121	.121	.121		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.121	.121	.120	.120		
X	0.308	0.313		.311	.311	.311	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.628	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.252	.250	.254	.254		
AE	1.375	1.395		1.3867	1.386	1.3855	1.3865		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.249	.250	.251		
AI	2.000	2.020		2.0016	2.0012	2.0002	2.0016		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	H
Date:	13-5-23

Audited by:	DAS
Date:	13-5-23

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

RELEASED
R 2013-01-07

DETAIL C B5-1
SCALE 2X

VIEW B-B B4-1

D2571 OUTER FWD SADDLE

- NOTES:
- 1) MATERIAL: 70/5/17351 PER QQ-A-250/12 (REF DART SPEC. D8161-307)
 - 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFY WITH DART PIN "D2571" AND BN PER DART QSI 044 6.3 (CNC ENGRAVING)
USE MAX DEPTH OF 0.010 WITH MIN TOOL RAD OF 0.010
 - 7) WEIGHT: 1.07 lbs

REV.	DESCRIPTION	DATE
F	D6101-007 WAS D6102-001 REF NCR12-1832	12.11.13
E	ADD CHAMFER ON RIDGE. NOTE 5	06.07.13
D	ADD RIDGES. TIGHTEN TOLERANCES	02.09.06
C	INCOMP. DEC 912300799120 ADD DIMENSIONS PER TSR A1177	09.10.22
B	ADD GRIN DIR. 0438 WAS 0.425	09.12.02
A	NEW ISSUE	09.09.16
BY		
DATE		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. F
DRAWING NO. D2571
SHEET 1 OF 1

TITLE
OUTER FWD SADDLE

SCALE
NTS

DATE 12.11.13

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DATE 12/11/13 BY 100289 MJS

100289 MJS